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WELD INSPECTION		PREPARED BY: <u>Michael D. Hines</u> 8-10-83 DATE APPROVED BY: <u>CT. [Signature] for RGTason</u> 8/11/83 DATE		

1.0 REFERENCES

- 1-A G&H Specification SS-16B, "Structural Steel"
- A.1 G&H Specification SS17, "Miscellaneous Steel"
- A.2 AWS D1.1-75, "Structural Welding Code"
- A.3 ANSI B31.1, 1973 Edition, Winter 1974
- A.4 ASME Section III, Subsection NF, Summer 1977 Edition
- A.5 ASME Section III, Subsection NB, NC, ND, Summer 1974 Edition
- A.6 ASME Section VIII, Edition - per item contract date
- A.7 AWS-A2.0, 1968 Edition
- 1-B QI-QP-2.1-19, "Qualification of Weld Inspection Personnel"
- 1-C CP-QP-13.0, "Control of Measuring and Test Equipment"
- 1-D CP-QP-16.0, "Nonconformances"
- 1-E CP-QP-17.0, "Corrective Action"

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**CONTROL NO.** 11-102

2.0 GENERAL

2.1 PURPOSE AND SCOPE

The purpose of this procedure is to outline the Visual Weld QC Inspection Program to satisfy the requirements of Reference 1-A, 1-B, 1-C, and 1-D. This procedure applies to all Non-ASME structural and miscellaneous steel welding inspections.

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## 2.2 RESPONSIBILITY AND AUTHORITY

The Quality Engineering Supervisor, or his designee, is responsible for the development of specific inspection instructions for inspector use.

The Quality Control Supervisor is responsible for the implementation and administration of inspection activities.

## 3.0 PROCEDURE

### 3.1 PERSONNEL TRAINING

Personnel training shall be provided in accordance with Reference 1-B to assure that Non-ASME Weld QC inspection personnel achieve and maintain inspection proficiency.

### 3.2 INSPECTION DETAILS

Quality Instructions supplementing this Procedure identify the structural/miscellaneous steel inspection activities and delineate inspection criteria to assure that construction activities comply with design specifications and applicable codes and standards.

### 3.3 MEASURING AND TEST EQUIPMENT

Measuring and test equipment is calibrated, adjusted and maintained at prescribed intervals to provide confidence in the accuracy of the resulting data. Calibration responsibilities and requirements are defined in Reference 1-C.

### 3.4 STATUS INDICATORS

The status of inspected items is identified on appropriate documentation as defined by the applicable Quality Instruction.

### 3.5 NONCONFORMING ITEMS

Nonconformances shall be reported as outlined in each Quality Instruction.

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### 3.6 DOCUMENTATION METHODS

Quality Instructions specify the documentation required to provide objective evidence of compliance with specified Engineering/Construction criteria. Upon completion, these records shall be submitted for review, processing and filing in accordance with CPSES requirements for QA records.

### 3.7 CORRECTIVE ACTION

The Quality Engineering Supervisor, or his designee, shall review deficiencies and nonconformances and recommend required corrective action in accordance with Reference 1-E.